

Date: Friday, 9/1/2006 12:17:03 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 28404	Part Number	: D26651
Estimate Number	: 10818	Drawing Number	: D2665 REV. C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/1/2006	Drawing Revision	: C
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 9/30/2006
Previous Run	: 27965	Qty:	12
Written By	: <i>KA</i>	Um:	Each
Checked & Approved By	: <i>KA 06.09.01</i>		
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no <u>B25348</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection last completed on <u>06.09.14</u> by <u>SA</u> 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 7-Deburr <u>SA 06.09.14</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>SA 06.09.14</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SA 06.09.14</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/03
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:03 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 28404

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 06/09/26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M. 06-09-27

(12)

(12)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/10/02 x12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/02 (12)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 345

DOCUMENT CONTROL

06/10/02 (12)

10.0 DC



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/03

Job Completion



06/09/03

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	28404
Description: 206 Saddle, Outboard, Left side				Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.124	.123	.122		
B	0.100	0.140		.124	.127	.123	.124		
C	1.125	1.145		1.134	1.133	1.133	1.137		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.250	.255	.250	.250		
F	1.313	1.343		1.326	1.326	1.326	1.326		
G	0.210	0.230		.218	.229	.223	.222		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.572	1.569	1.572	1.572		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.106		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.007	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.792	.794	.793		
W	0.540	0.560		.548	.550	.547	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.925	.925	.926	.925		
AA	0.490	0.510		.492	.499	.498	.500		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	EN
Date:	06.09.14	Date:	06/08/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	JLM

DART AEROSPACE LTD		Work Order:	28404
Description: 206 Saddle, Outboard, Left side		Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.122	.123	.122		
B	0.100	0.140		.120	.122	.122	.122		
C	1.125	1.145		1.135	1.135	1.136	1.136		
D	0.615	0.685		.663	.665	.663	.665		
E	0.240	0.260		.250	.250	.250	.251		
F	1.313	1.343		1.328	1.328	1.328	1.320		
G	0.210	0.230		.223	.223	.223	.222		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.570	1.571	1.573	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.105		
M	0.990	1.010		1.001	1.000	1.000	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.001	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.791	.794	.792	.794		
W	0.540	0.560		.549	.549	.549	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.929	.926	.925	.924		
AA	0.490	0.510		.499	.500	.497	.495		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.09.14

Audited by:	ER
Date:	06.10.14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	SD

DART AEROSPACE LTD		Work Order:	28404
Description: 206 Saddle, Outboard, Left side		Part Number:	D2665-1
Inspection Dwg: D2665 Rev. C			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

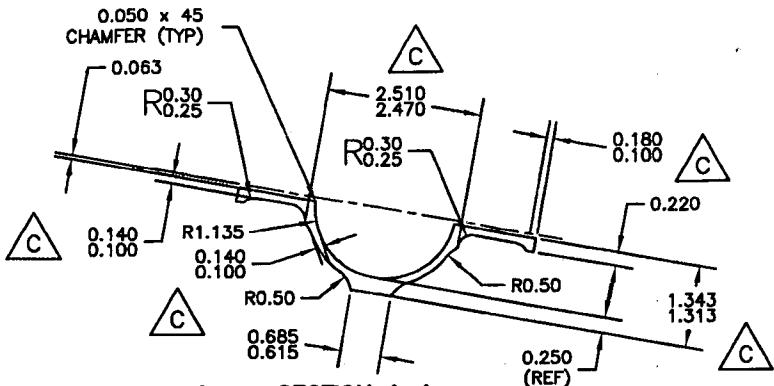
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.122	.123	.123	.124		
B	0.100	0.140		.122	.122	.123	.122		
C	1.125	1.145		1.136	1.139	1.135	1.136		
D	0.615	0.685		.665	.665	.665	.665		
E	0.240	0.260		.249	.250	.251	.254		
F	1.313	1.343		1.326	1.327	1.326	1.326		
G	0.210	0.230		.223	.223	.223	.224		
H	0.100	0.180		.138	.138	.138	.138		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.573	1.575	1.572	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.105	.105	.105	.105		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.313	0.318		.316	.318	.318	.318		
T	2.495	2.505		2.498	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.795	.795	.798	.797		
W	0.540	0.560		.558	.549	.547	.548		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.921	.921	.920		
AA	0.490	0.510		.498	.494	.496	.496		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	EN
Date:	06.09.16	Date:	66/09/16

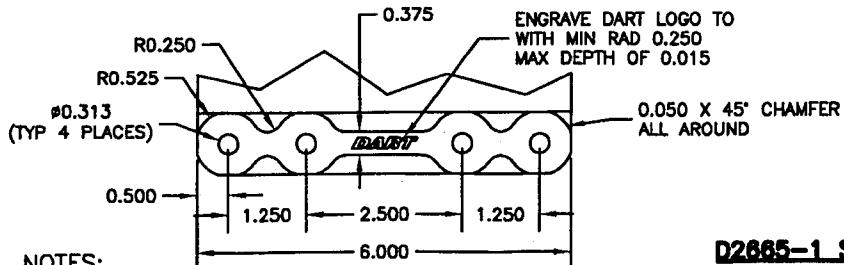
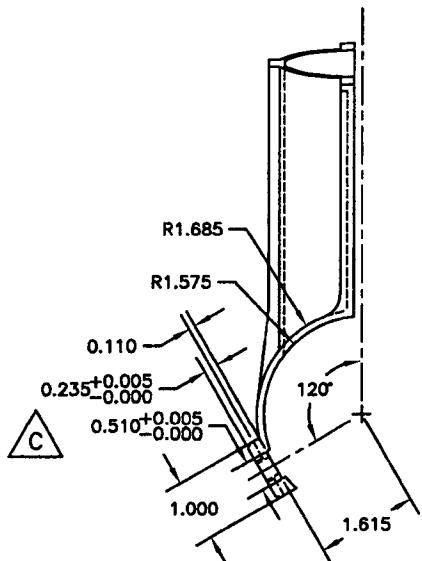
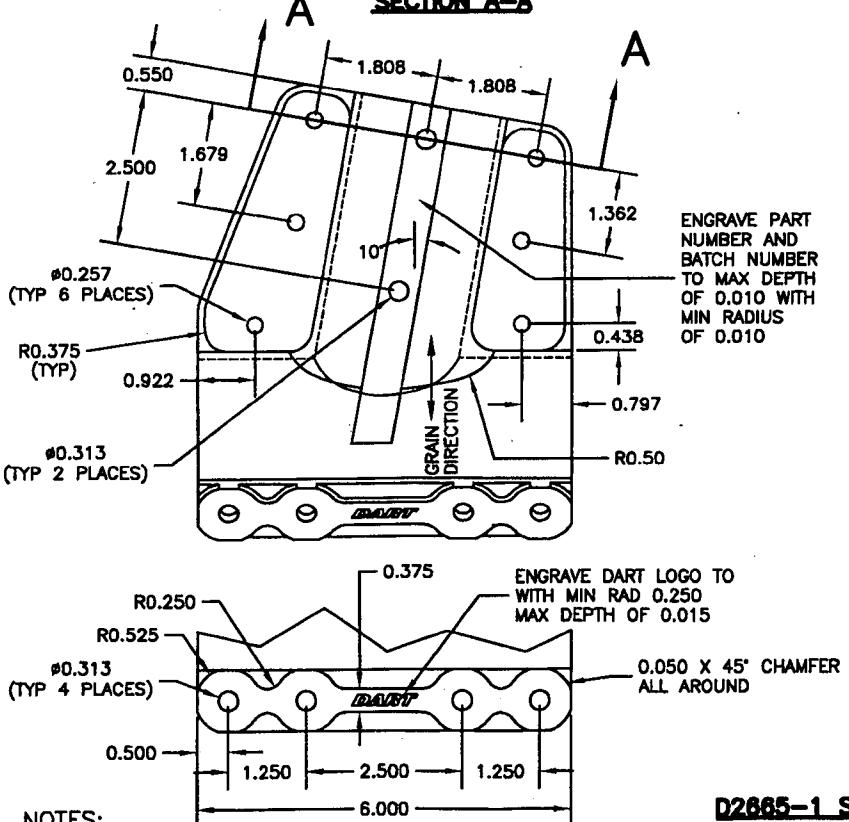
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	SD

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
	C.B.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2665	SHEET 1 OF 1
DATE		SCALE	
06.05.29		SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	



RELEASED
06.06.28



NOTES:

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28404

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